

4. Flat or semi-flat element (1) according to [any of the claims 1 - 3 characterised] claim 1 characterized in that the frame (2) is a closed hollow profile formed through injection of a [pressurised] pressurized fluid into a still molten thermoplastic material, that the material thickness of the wall section (3) is thinner closest to the connection between the frame (2) and the wall section (3) than the average thickness of the wall section (3) and the frame (2), whereby a barrier is formed in this connection part at the solidification of the thermoplastic material, [wich] which barrier prevents the [pressurised] pressurized fluid from entering the wall section (3) during the manufacturing process.

[Please add new claims 8-9 as follows:]

--8. Flat or semi-flat element (1) according to claim 2 characterized in that the frame (2) is a closed hollow profile formed through injection of a pressurized fluid into a still molten thermoplastic material, that the material thickness of the wall section (3) is thinner closest to the connection between the frame (2) and the wall section (3) than the average thickness of the wall section (3) and the frame (2), whereby a barrier is formed in this connection part at the solidification of the thermoplastic material, which barrier prevents the pressurized fluid from entering the wall section (3) during the manufacturing process.

9. Flat or semi-flat element (1) according to claim 3 characterized in that the frame (2) is a closed hollow profile formed through injection of a pressurized fluid into a still molten thermoplastic material, that the material thickness of the wall section (3) is thinner closest to the connection between the frame (2) and the wall section (3) than the average thickness of the wall section (3) and the frame (2), whereby a barrier is formed in this connection part at the solidification of the thermoplastic material, which barrier prevents the pressurized fluid from entering the wall section (3) during the manufacturing process.--

$\Delta D_c$ 

Please add new claims 10-11 as follows:

503  
12  
B D'

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Please add new claims 12-15 as follows:

27  
SUB D  
B 13

21  
sub D  
B 13